



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2654-5

Job Sheet 201404



Part No: D2654-5

Job Qty: 8 pcs

Part Name: Web



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/19

Job Tracking No:

Due Date: 10/17/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F SHEET 2 IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	8 pcs	10/17/19		0.00	4.37	Skidtubes - 1		TF
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	8 pcs	10/17/19		0.00	0.00	QC 5 - 10		BE
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1-1 Chemical-B4B	8 pcs	10/17/19		0.00	1.90	Handfinish - 1 - 1 - B4B		BEB 19-10-08
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		



Container No: S220149



Part: D2654-5

Job No: 201404

Serial No/Batch: S220149

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/07/19

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					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
130	QC 7	8	10/17/19	0.00 0.00	QC 7 - 10	
		pcs			QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	79
						80

				QC 7 - 79	
140 Packaging 3-1 - Stock - B4B	8 pcs	10/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	TF
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	8 pcs	10/17/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-89
				QC 21 - SA - 53	OCT 09 2019

Part Op 100 - (Skidtubes) 1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-5 as perDwg Descriptions: D2654

110 - (QC5- Inspect part completeness to step on W/O)

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

140 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-7-140	Extrusion I-Beam Thick	8 pcs (1 ea)	100-Skidtubes - 1	B162496

Job Allocations

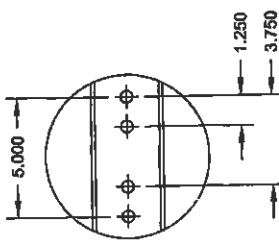
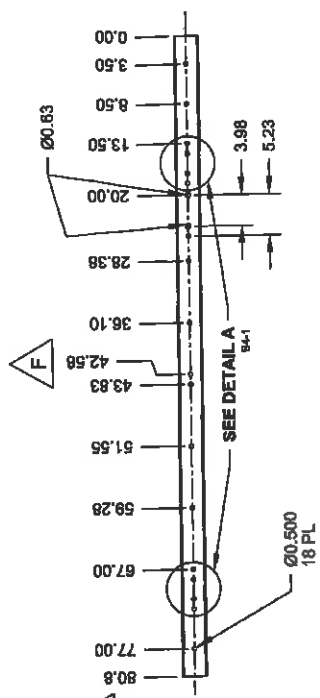
Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2600-7-140	8	119	0

Part Specifications
Specifications could not be found.

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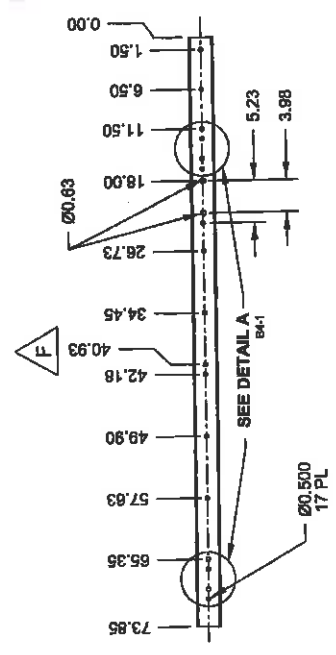
RELEASED
R 2011-09-12

D2654-3 WEB



DETAIL A

D2654-1 WEB



- NOTES:
- 1) MAKE D2654-1/3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/7 FROM D2600-7-125 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH PIN "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.3 lbs

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/7, 80.8 WAS 80.5, INCORPORATED DED D2654-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.20
D	GHW HOLES CHANGED TO Ø0.83	CP	06.01.16
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.28
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	SC	
DRAWN	CP	SC	
CHECKED	CP	SC	
MFG. APPR.	CP	SC	
DE APPR.	CP	SC	
DATE	11.05.05		

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D2654
SHEET 1 OF 2
SCALE
NTS
DATE 11.05.05

CP: 0.005 INCHES UNLESS OTHERWISE NOTED
QSI 018 UNLESS OTHERWISE NOTED
QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

DISPOSITION						DEPARTMENT/PROCESS							
Job: _____		Rework ☐		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality			
Part No. _____		Use-as-is ☐		Large Fab ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Water Jet ☐			
Date :	Sequence #:			QTY Affected :			MRB (QS042)						
Description Work Order Deviation							Disposition						
							Completed By						
							Lead hand / Supervisor						
							QC / QA Coordinator						

Root Cause		FAULT CATEGORY											
Operator	☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐				
Manufacturing Process	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐				
Equip/Tooling	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐				
Handling/Presservation	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐				
Material	☐	Crimp/kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐				
Product Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐				
Process Improvement	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐						
Human Factors	☐	Other/Details:											